

Work Order ID 131223

March-31-15 8:07:09 AM

\*131223\*

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Item ID: D4964-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Step Leg

Start Date: 3/31/15

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 4/06/15

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4964

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

(4)

02/15/03/31

(4)

02/15/03/31

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4x 15/07/02 DAS 36 9-8

DAS  
36  
9-89

# Work Order ID 131223

**\*131223\***

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March-31-15 8:07:09 AM

Item ID: D4964-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Leg  
 Start Date: 3/31/15 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 4/06/15 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            | Identify as per dwg & Stock Location        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                        | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                             |                      |         |        |              |               |               |                  |                |
| 160                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

*Handwritten:* 15.42

# Picklist Print

March-31-15 8:07:08 AM

Page 1

Work Order ID: 131223

**\*131223\***

Parent Item: D4964-1

**\*D4964-1\***

Parent Item Name: Step Leg

Start Date: 3/31/15

Required Date: 4/06/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6S.080

Purchased

No

sf

208.1918

4

**\*M6061T6S 080\***

6061-T6 .080 Sheet

**\*\***

*02/15/04/01*

Location

Loc Qty

Loc Code

MAT020

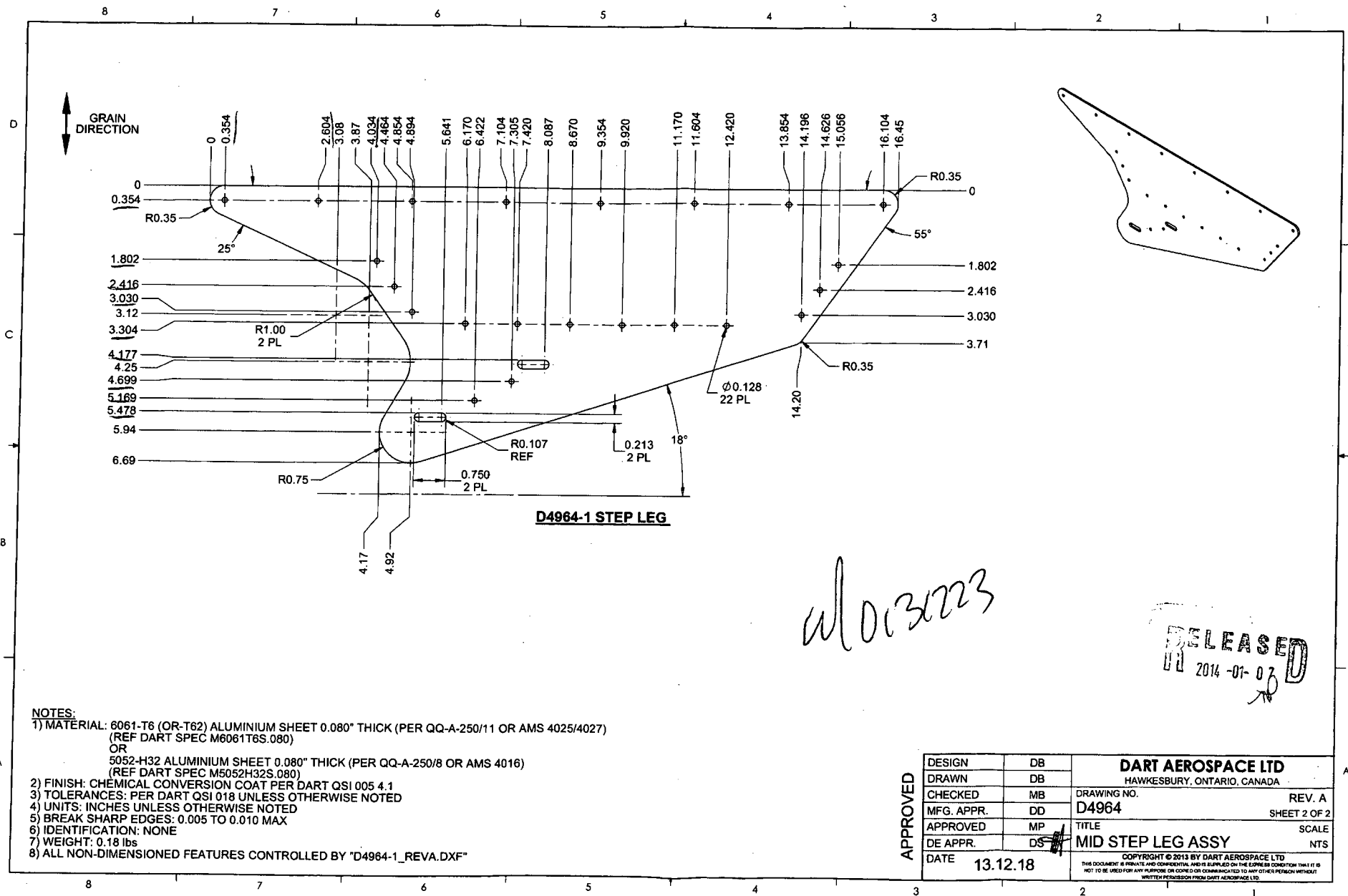
208.1918

45.5

3.8

*m13056*

162.6918



# NOTES:

- 1) MATERIAL: 6061-T6 (OR-T62) ALUMINIUM SHEET 0.080" THICK (PER QQ-A-250/11 OR AMS 4025/4027)  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 ALUMINIUM SHEET 0.080" THICK (PER QQ-A-250/8 OR AMS 4016)  
(REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY "D4964-1\_REVA.DXF"

APPROVED

|            |          |                                                                                                                                                                                                                                                                                |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DB       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |              |
| DRAWN      | DB       |                                                                                                                                                                                                                                                                                |              |
| CHECKED    | MB       | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. A       |
| MFG. APPR. | DD       | <b>D4964</b>                                                                                                                                                                                                                                                                   | SHEET 2 OF 2 |
| APPROVED   | MP       | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   | DS       | <b>MID STEP LEG ASSY</b>                                                                                                                                                                                                                                                       | NTS          |
| DATE       | 13.12.18 | COPYRIGHT © 2013 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

|                                           |  |              |        |
|-------------------------------------------|--|--------------|--------|
| DART AEROSPACE LTD                        |  | Work Order:  | 131223 |
| Description: <u>Step leg</u>              |  | Part Number: | 4964-1 |
| Inspection Dwg: <u>4964</u> Rev: <u>A</u> |  | Page 1 of 1  |        |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension  | Tolerance                        | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|----------------------------------|------------------|--------|--------|----------------------|----------|
| $\varnothing .128$ | $-.001 +.005$                    | .128             | /      |        |                      |          |
| .213               | $+/- .010$                       | .214             | /      |        |                      |          |
| .750               | $+/- .010$                       | .750             | /      |        |                      |          |
| .354               | $+/- .010$                       | .354             | /      |        |                      |          |
| .354               | $+/- .010$                       | .354             | /      |        |                      |          |
| 1.802              | $+/- .010$                       | 1.804            | /      |        |                      |          |
| 2.604              | $+/- .010$                       | 2.602            | /      |        |                      |          |
| 2.416              | $+/- .010$                       | 2.418            | /      |        |                      |          |
| 3.030              | $+/- .010$                       | 3.032            | /      |        |                      |          |
| 3.304              | $+/- .010$                       | 3.309            | /      |        |                      |          |
| 4.177              | $+/- .010$                       | 4.177            | /      |        |                      |          |
| 4.699              | $+/- .010$                       | 4.704            | /      |        |                      |          |
| 5.169              | $+/- .010$                       | 5.174            | /      |        |                      |          |
| 5.478              | $+/- .010$                       | 5.484            | /      |        |                      |          |
| 6.69               | $+/- .010$                       | 6.696            | /      |        |                      |          |
| <del>4.034</del>   | <del><math>+/- .010</math></del> |                  |        |        |                      |          |
| <del>4.164</del>   | <del><math>+/- .010</math></del> |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |
|                    |                                  |                  |        |        |                      |          |

|                        |                          |                       |
|------------------------|--------------------------|-----------------------|
| Measured by: <u>DL</u> | Audited by: <u>38</u>    | Preliminary Approval: |
| Date: <u>15/03/31</u>  | Date: <u>APR 01 2015</u> | Date:                 |

| Rev | Date     | Change                     | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E   | 10.04.14 | Added preliminary approval | KJ         |          |